

Date: Wednesday, 3/8/2006 10:38:09 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 26114 -1
 Estimate Number : 12187
 P.O. Number : NIA
 This Issue : 3/8/2006 S.O. No. : NIA
 Prsht Rev. : NC
 First Issue : NIA Type : PURCHASED PARTS
 Previous Run : NIA
 Written By : SAE (COMMENT BELOW)
 Checked & Approved By : [Signature] 06.03.08
 Comment : est rev A 06.02.06 new issue EC

Drawing Name : SHUT-OFF VALVE SHAFT
 Part Number : D34695
 Drawing Number : D3469 REV.A
 Project Number : N/A
 Drawing Revision : A
 Material : NIA
 Due Date : 3/31/2006 Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 OUTSIDE SERVICE OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES
 Issue P/O: 00000768
 Email or Ship DXF file to vendor
 Laser Cut per Dwg D3469 flat pattern D3469-5F
 Material release note required

2.0 D34695 F LOWER PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 ARM

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0 NAS1031C3W Nutplate



Comment: Qty.: 17.0000 Each(s)/Unit Total : 102.0000 Each(s)
 pick:

Qty Part number Description Batch
 17 NAS1031C3W Nutplate M19651, M19505

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Drawing Name: SHUT-OFF VALVE SHAFT

Job Number: 26114

Part Number: D34695

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Deburr if necessary

2-form oval flanges per dwg D3469 using DT8850

3-Spot weld nut plates as per dwg D3469

BOG 03-28 ①

7.0

QC5

INSPECT WORK TO CURRENT STEP



BOG 02-30



Comment: INSPECT WORK TO CURRENT STEP

8.0

OUTSIDE SERVICE

OUTSIDE SERVICES

Comment: Sub-Contracting OUTSIDE SERVICES
Issue P/O: _____
Electro Chemically Polish as per Dwg D3479
Ensure Certificate of Conformity is attached

N/A

BOG 03-06

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

BOG 03-30 ①

11.0

DC

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Inspection Level 21

BOG 06/03/31 ①

Job Completion



BOG 06/03/30

